

Work Order ID 77348

Tuesday, December 06, 2011 9:53:00 AM

77348

ASAP

Page 1

Item ID: D4165-7 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Rib
 Start Date: 12/6/2011 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 12/8/2011 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: *mf* Date: *11-12-06* Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4165	B								

100 0.00
100
 Waterjet *B11-12-6*
 FLOW CNC Waterjet
2024.040
 Memo
 1-Cut as per Dwg
 Dwg Rev: *B*
 Prog Rev: *B*
 2-Deburr if necessary *(2)*

110 0.00
110
 QC *B11-12-6*
 Quality Control
 Memo

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		8 u12/07					
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		11-12-07					
135 *135* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							

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Page 3

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Fwd Rib

Stop ***NS2***

Start Date: 12/6/2011 Start Qty: 2.00

2

Cust Item ID:

Required Date: 12/8/2011 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Identify as per dwg & Stock Location: _____

0.00


140

Packaging

Memo

0.00

Packaging

11/12/7  20

150

QC21- Final Inspection - Work Order Release

0.00


150

QC

Memo

0.00

Quality Control

11/12/8 ME
11-12-07

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Picklist Print

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Page 1

Work Order ID: 77348

Parent Item: D4165-7

Parent Item Name: Fwd Rib

Start Date: 12/6/2011

Required Date: 12/8/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 11.03.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040 2024-T3 .040 sheet		Purchased	No			100	sf	69.8184	0.68	1.4315789			

1511-12-6

Location

Loc Qty

Loc Code

MAT022

69.818421

117684

69.818421

117684

2

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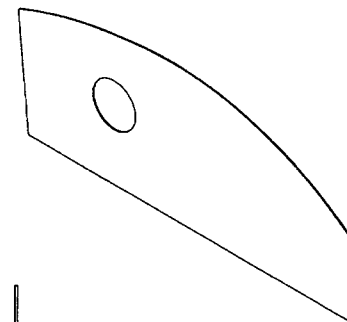
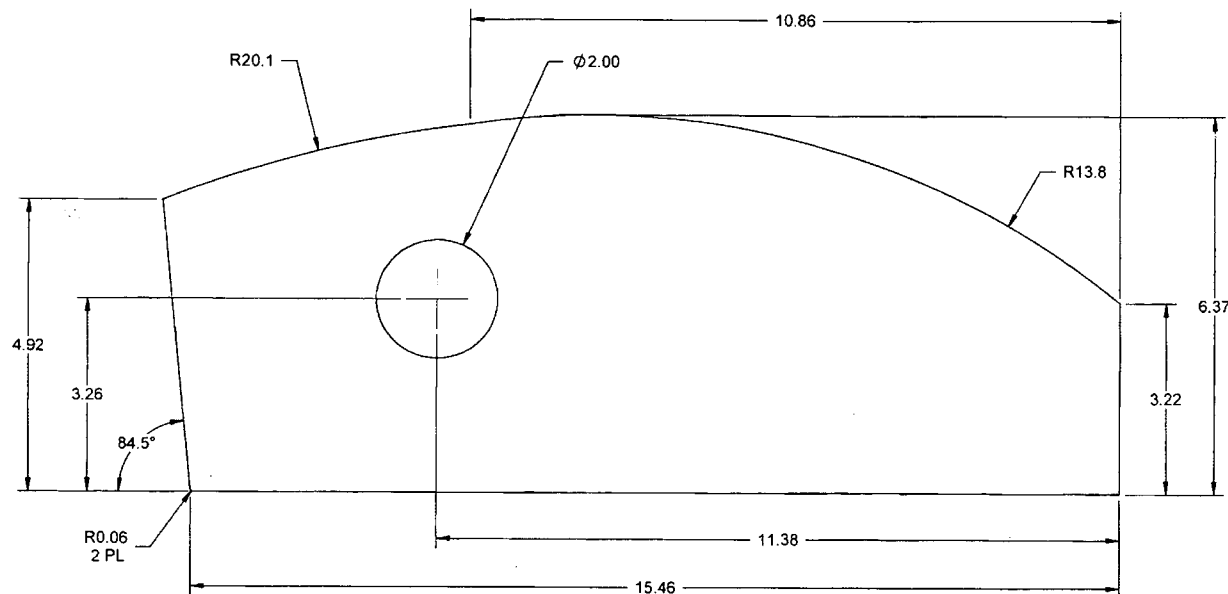
8 7 6 5 4 3 2 1

D

C

B

A



D4165-7 FORWARD RIB
(REF. EAGLE DRAWING No. D2046902 P/N EA24069-31)

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037
OR ASTM B209
PER DART SPEC M2024T3S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.33 lbs

4 7734
RELEASED
2011-04-15
JH

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4165	SHEET 4 OF 7
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	VRD PARTS	NTS
DATE	11.04.11	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

Dart Aerospace Ltd

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